

Date: Wednesday, 4/19/2006 1:08:40 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT GUSSET (350) BASKET
Job Number : 26741	
Estimate Number : 10496	
P.O. Number : N/A	Part Number : D2325
This Issue : 4/19/2006 S.O. No. : N/A	Drawing Number : D2325 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 25687	Material : N/A
Written By : <u>See Comment Below</u>	Due Date : 4/26/2006 Qty: 50 Um: Each
Checked & Approved By : <u>06.04.19</u>	
Comment : Est. D 02.12.06 Reformat; Rev B KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 1043

Email or ship DXF file to vendor Make as per Dwg D2325,

Material: 304 SS .063" Thick

Material release note required

C Ldc 104/20 (50)

2.0	D2325F	Support Gusset (350 Bask
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
Support Gusset (350 Bask

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

60 0/0/2 51

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

06.05.04 (51)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr if necessary

H.M 06/05/05

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: D Date: 06/05/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/19/2006 1:08:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT GUSSET (350) BASKET

Job Number: 26741

Part Number: D2325

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGIN

Identify and Stock

Location: WS

AA 06/05/08 50

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Q 06/05/08 (50)

Job Completion



4 de 05/08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

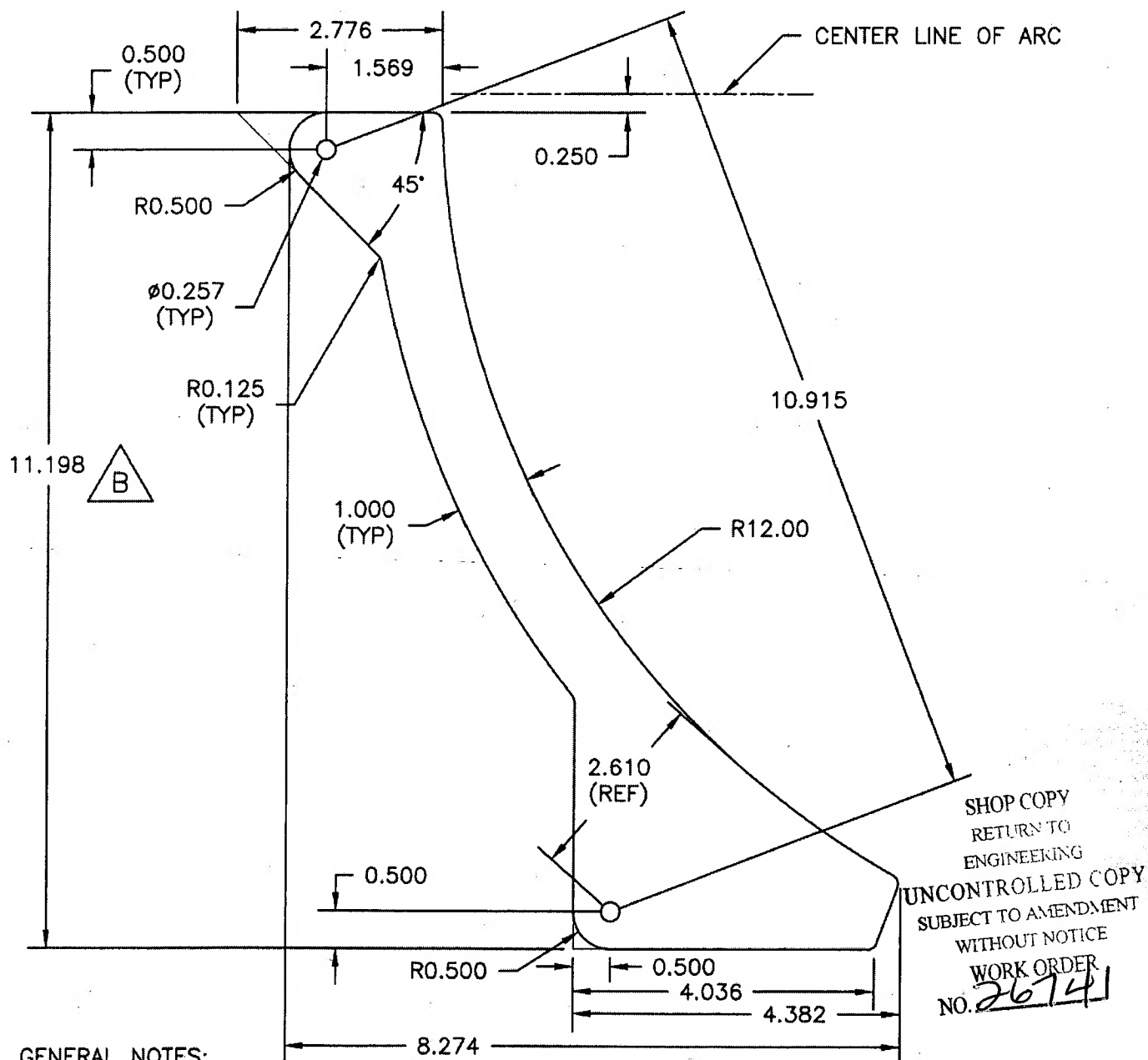
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2325	REV. B SHEET 1 OF 1
DATE 02.08.28		TITLE SUPPORT GUSSET	SCALE 1:2
A	94.12.13	NEW ISSUE	
B	02.08.28	REFORMAT; 11.198 WAS 11.948	

RELEASED
02.08.29



GENERAL NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.063 THICK (REF DART SPEC. M304S16GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Paragraph 4.3 by TÜV Anlagentechnik GmbH (NOMEN DUOY)

Inspection Certificate EN10204-3.1B

P60124PC001

Shanxi Taiyuan Stainless Steel CO.,LTD Member
of Taiyuan Iron and Steel (Group) Co.,LTD

NO.2 jincaoping, Taiyuan, Shanxi, P.R.China

TEL: (0351)3013328 FAX: (0351)3017816

http://www.tisco.com.cn

E-mail: tgbkg@tisco.com.cn

MILL TEST CERTIFICATE

MATERIAL	AISI304 No.2B Finish	060504
SPECIFICATION	ASTM A240/A480	ASME SA240/SA480
L/C NO.		
CERTIFICATE NO.	20051187	
DATE OF ISSUE	//	

CUSTOMER	CONTRACT NO.	DATA OF
OLBERT	1187	2005/11/20

Product	Melting furnace	Inspection stamp	Mark of the Manufacturer
COIL	E+VOD		Shanxi Taiyuan Stainless Steel Co., Ltd

NO.	Heat No.	Coil No.	Quantity	Dimensions	Weight (kg)
8.	4505286	5A9-485-12D	1	11GA x 48 x C	7009
9	Y506019	5A9-485-12B	1	11GA x 48 x C	6679
10	4505044	5A9-485-12Y	1	14GA x 48 x C	5461
11	4505274	5A9-480-12D	1	11GA x 48 x C	4832
12	4505271	5A10-44-32J	1	16GA x 48 x C	8906
13	4505050	5A10-53-32J	1	16GA x 48 x C	8617
14	4505393	5A10-70-42Y	1	14GA x 48 x C	8642

Chemical Composition

Heat No.	C	Si	Mn	P	S	Cr	Ni	Cu	Al	Mo	N
4505286	0.060	0.470	1.400	0.017	0.003	18.170	8.020	0.010	0.010	0.010	0.035
Y506019	0.050	0.350	0.990	0.012	0.004	18.300	8.090	0.440	0.006	0.120	0.070
4505044	0.060	0.450	1.370	0.018	0.002	18.200	8.120	0.010	0.010	0.010	0.050
4505274	0.060	0.320	1.320	0.017	0.002	18.150	8.120	0.010	0.010	0.010	0.043
4505271	0.060	0.470	1.320	0.016	0.003	18.170	8.110	0.010	0.010	0.010	0.043
4505050	0.050	0.480	1.290	0.014	0.002	18.220	8.040	0.010	0.010	0.010	0.045
4505393	0.070	0.480	1.260	0.017	0.002	18.200	8.070	0.010	0.010	0.010	0.040

Mechanical Properties

Test No.	Tensile Rm N/mm ²	R _{0.2} Yield _{0.2%} N/mm ²	R _{p0.01} Yield _{0.01%} N/mm ²	Elongation A5%	Corrosion Tests	Hardness		
						HRB	HV	HRC
4505286-T	635	282		55		84 - 83		
Y506019-T	650	266		53		88		
4505044-T	675	307		39		83 - 83		
4505274-T	690	299		56		86 - 85		
4505271-T	700	326		54			188 - 186	
4505050-T	695	297		57			190 - 188	
4505393-T	640			60		86 - 85		

Surface and dimensions controlled:

Work Inspector

T. X. S.



P60124PC001V 3042B .062X48 HT 4505271 4505050

Page 2 of 3

MATERIAL TEST/INSPECTION CERTIFICATE



YIEH MAU CORP.

 INVOICE NO. : F05MB11
 COMMODITY : PRIME COLD ROLLED STAINLESS STEEL SHEET

90270957

 工廠:高雄新橋竹寮頂安路345號
 345, SHUN AN RD. LU CHU HSIAO
 KAOHSIUNG TAIWAN R.O.C.
 TEL:8078972385 FAX:8078973006
 CERTIFICATE NO. F05MB11
 DATE OF ISSUE: 12/30/2005
 PAGE 2/3

 SPECIFICATION : AISI 304
 CUSTOMER : INTEGRIS METALS LTD.

ITEM NO.	SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties Tensile Test GL-50 m/m					Chemical Composition (%)							
			KGS	LBS			Y _S (N/mm ²)	Y _T (N/mm ²)	EL (%)	HRB	HV	C x100	Si x100	Mn x100	P x1000	S x1000	N x100	Cr x100	Ni x100
AIS 304, NO. 4 (SIC) FINISH, WITH 100 MIC. FILM ON MAIN SIDE, WITH BACK-PASS, SLITTED EDGE.																			
7426-3530	18GA\48"X144"	1	1,435	3,164	YU139529	4BS18564-12	296	655	53	83	164	4.6	51	89	35	5	805	1836	2.2
7426-3539	18GA\60"X120"	1	1,424	3,139	YU137844	4BS18468A-11	308	701	50	83	165	4.7	50	117	31	5	804	1813	3
7426-6159	16GA\48"X 96"	1	1,445	3,186	YU189710	4BS18697-14	297	639	52	84	168	3.6	49	110	34	3	812	1818	3.2
7426-6159	16GA\48"X 96"	1	1,445	3,186	YU138210	4BS18697-15	297	639	52	84	168	3.6	49	110	34	3	812	1818	3.2
7426-6159	16GA\48"X 96"	1	1,445	3,186	YU139710	4BS18697-16	297	639	52	84	168	3.6	49	110	34	3	812	1818	3.2
7426-6288	16GA\48"X120"	1	1,462	3,223	YU139710	4BS18697-17	297	639	52	84	168	3.6	49	110	34	3	812	1818	3.2
7426-6288	16GA\48"X120"	1	1,462	3,223	YU139710	4BS18697-18	297	639	52	84	168	3.6	49	110	34	3	812	1818	3.2
7426-6288	16GA\48"X120"	1	1,464	3,223	YU139710	4BS18697-19	297	639	52	84	168	3.6	49	110	34	3	812	1818	3.2
7426-6343	16GA\60"X 96"	1	1,440	3,175	YU140033	4BS18975B-11	295	674	51	84	168	3.8	49	116	32	11	805	1804	2.7
7426-6353	16GA\60"X120"	1	1,418	3,126	YU140033	4BS18975B-16	295	674	51	84	168	3.8	49	116	32	11	805	1804	2.7
7426-6353	16GA\60"X120"	1	1,195	2,635	YU140033	4BS18975B-17	295	674	51	84	168	3.8	49	116	32	11	805	1804	2.7
7426-6363	16GA\60"X144"	1	1,376	3,031	YU140033	4BS18975B-12	295	674	51	84	168	3.8	49	116	32	11	805	1804	2.7
7426-6363	16GA\60"X144"	1	1,374	3,029	YU140033	4BS18975B-13	295	674	51	84	168	3.8	49	116	32	11	805	1804	2.7
7426-9049	14GA\48"X120"	1	1,426	3,144	YU140207	4BS20605A-11	314	704	49	86	175	5.5	51	125	35	9	808	1818	1.8
7426-9049	14GA\48"X120"	1	1,421	3,133	YU140207	4BS20605A-12	314	704	49	86	175	5.5	51	125	35	9	808	1818	1.8
7426-9049	14GA\48"X120"	1	1,421	3,133	YU140207	4BS20605A-13	314	704	49	86	175	5.5	51	125	35	9	808	1818	1.8
7426-9265	14GA\60"X120"	1	1,442	3,179	YU140018	4BS19431A-11	306	672	50	83	173	4.9	47	118	32	10	804	1830	2.8
7427-4844	12GA\48"X120"	1	1,862	4,093	YU236779	4BS18646A-113	308	641	53	84	166	4.6	48	118	35	4	814	1822	3.4
7427-4844	12GA\48"X120"	1	1,862	4,093	YU236779	4BS18646A-114	308	641	53	84	166	4.6	48	118	35	4	814	1822	3.4
7427-7166	11GA\48"X 96"	1	1,473	3,247	YU140191	4BS20468A-113	300	673	52	84	167	4.8	53	127	32	5	804	1806	3.1
7427-7166	11GA\48"X 96"	1	1,478	3,247	YU140191	4BS20468A-114	300	673	52	84	167	4.8	53	127	32	5	804	1806	3.1
7427-7177	11GA\48"X120"	1	1,308	2,884	YU236346	4BS20448A-211	293	655	51	83	162	4.1	49	124	33	7	810	1817	3
7427-7177	11GA\48"X120"	1	1,313	2,895	YU236346	4BS20448B-118	293	655	51	83	162	4.1	49	124	33	7	810	1817	3
7427-7177	11GA\48"X120"	1	1,312	2,892	YU236346	4BS20448B-116	293	655	51	83	162	4.1	49	124	33	7	810	1817	3
7427-7177	11GA\48"X120"	1	1,310	2,901	YU140191	4BS20468B-211	300	673	52	84	167	4.8	53	127	32	5	804	1806	3.1
7427-7177	11GA\48"X120"	1	1,316	2,901	YU140191	4BS20468B-212	300	673	52	84	167	4.8	53	127	32	5	804	1806	3.1
7426-8430	18GA\36"X144"	1	1,458	3,203	YU236224	4BS20618-114	306	662	54	84	168	4.2	52	128	33	8	802	1815	3.3
7426-8420	15GA\36"X144"	1	1,453	3,203	YU236224	4BS20618-116	306	662	54	84	168	4.2	52	128	33	8	802	1815	3.3

2E 59.285 35.492

NO MERCURY CONTAINMENT

Read (continued for all Heat No.)

 REMARKS: NO MERCURY CONTAMINATION
 WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS
 BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE.

Send test report for all Heat NO.

- PRIME MATERIAL. NO DINGS, NO DENTS, NO SCRATCHES
- P.O. NO. 487694 (VANCOUVER)
- SALES CONTRACT NUMBER: F05MB11
- DOCUMENTARY CREDIT NUMBER: ILCMSPO00165

YIEH MAU CORP.

 Lin Kuan Hsing
 Manager of Quality Assurance